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Carl

D3560-041
Job Sheet 189817



Part No: D3560-041

Job Qty: 4 pcs

Part Name: Arm Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/30/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A New Issue 07.05.24 EC IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	Large Fab - Steps - 1	4 pcs	2/8/19		0.00	3.25	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
150	QC 5	4 pcs	2/8/19		0.00	0.00	Large Fab - 9		<i>SLu 2/6/19</i>
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
160	QC 9	4 pcs	2/8/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		

DAS
24
9-89

					QC 9 - 24	DAS 24 9-89
					QC 9 - 43	
					QC 9 - 50	
					QC 9 - 9	
170 Handfinish - 1-1 Chemical-B4B	4 pcs	2/8/19	0.00 0.50		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/2/7
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
180 QC 7	4 pcs	2/8/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	DAS 36 9-89
					QC 7 - 37	
					QC 7 - 38	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
190 Small Fab - 2 - B4B	4 pcs	2/8/19	0.00 0.11		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	DAS 36 9-89
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	

200 QC 5	4 pcs	2/8/19	0.00 0.00	Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	DAS 30 9.29
				QC 5 - 30	19
210 Packaging 3-1 - Stock - B4B	4 pcs	2/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	SL 2/7/19
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
220 QC 21 - SA	4 pcs	2/8/19	0.00 0.00	QC 21 - SA - 21	DAS 21 FEB 09 2019
				QC 21 - SA - 70	
Part Op 140 - (Weld per dwg A/R Aluminum rod Batch: <u>138872</u>), 1-Weld assembly as per dwg D3560 STEP: 1- clean material (buff Descriptions: bracket and bottom of arm with blue pad) 2- set up bracket and arm on jig 3- preheat bracket and arm with torch 4- clean before welding with brush 5- set up machine to 135 amps 6- weld across bottom and top ends 7- reheat with torch (65					

deg C) 8- on one side weld from bottom to top half way 9- same for other side (half way) 10- from half way point weld the rest of the first side (ease off pedal near end) 11- same for remaining side (ease off pedal near end)

150 - (QC5- Inspect part completeness to step on W/O)

160 - (QC9- Inspect visual per QSI004- Fusion Welds)

170 - (Chemical Conversion Coat per QSI005 4.1)

180 - (QC7-Inspect Chemical Conversion Coat)

190 - 1-Press bushing in D3560 arm per dwg D3562

200 - (QC5- Inspect part completeness to step on W/O)

210 - (Identify as per dwg & Stock Location: _____), *** STOCK IN STEP CELL *** LOCATION: WA003

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3560-1	Arm	4 pcs (1 ea)	140-Large Fab - Steps - 1	S150298
D3592-1	Plate	4 Ea (1 ea)	140-Large Fab - Steps - 1	S061044③
D2808	Spacer	4 pcs (1 ea)	190-Small Fab - 2 - B4B	S077174

S021150①

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
140-Large Fab - Steps - 1	D3560-1	4	0	0
	D3592-1	4	23	0
190-Small Fab - 2 - B4B	D2808	4	12	0

Part Specifications

Specifications could not be found.

Plex 1/30/19 2:55 PM Dart.lajeunesse.marie



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Container No: S151315



Part: D3560-041

Job No: 189817

Serial No/Batch: S151315

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/06/19